

Work Order ID 81007

Tuesday, March 06, 2012 1:36:42 PM

81007

Page 1

Item ID: D4149-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug Assembly, Aft

Start Date: 3/6/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/14/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12-03-06* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4149

C

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

110

QC5- Inspect part completeness to step on W/O 0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location *ST408* 0.00***120***

Packaging

Memo

0.00

Packaging

*SP 12/03/15 (6)**(46)**(6x) SP 12-03-16.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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6

Cust Item ID:

Required Date: 3/14/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/3/19 dJ

112-03-14

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Picklist Print

Tuesday, March 06, 2012 1:36:42 PM

Page 1

Work Order ID: 81007

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 3/6/2012

Required Date: 3/14/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM
DD verf:JLM

IPP Rev:C 11.03.03 as per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3 Nut		Purchased	No			100	Each	1,116.0000	4	12			

Location	Loc Qty	Loc Code
FG	72	
103691	72	
GA	362	
120693	362	
ST300	189	
119901	189	
ST301	493	
118077	2	
118614	441	
118686	30	
119758	20	

MS21043-4 Nut		Purchased	No			100	Each	1,442.0000	1	18			
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Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1402	
119546	439	
120308	963	

D3910-1 Crosstube Lug		Manufactured	No			100	Each	15.0000	1	6			
--------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
st507	15	
78326	15	

D4091-1 Mounting Lug		Manufactured	No			100	Each	0.0000	1	6			
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B81005

EF 3/12/03/15

EF 3/12/03/15

EF 3/12/03/15

EF 3/12/03/15

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Page 2

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Start Date: 3/6/2012

Required Date: 3/14/2012

Start Qty: 6.00

Required Qty: 6.00

D4149-1 Manufactured No
Crosstube Lug Plate, Aft

100 Each 7.0000 2 12

Location Loc Qty Loc Code

ST133 7

78044 7

D4149-3 Manufactured No
Spacer

100 Each 29.0000 1 6

Location Loc Qty Loc Code

ST133 29

78046 29

D4149-5 Manufactured No
Eyebolt Stud

100 Each 18.0000 1 6

Location Loc Qty Loc Code

ST133 18

79057 18

AN3C12A Purchased No
Bolts

100 Each 348.0000 2 12

Location Loc Qty Loc Code

GA 50

120449 50

ST351 298

117514 4

118112 5

118451 22

119510 1

120423 266

AN4C13A Purchased No
BOLT

100 Each 166.0000 3 18

Location Loc Qty Loc Code

ST357 166

120187 1

120423 165

Tuesday, March 06, 2012 1:36:42 PM

Shop Packet Print

Page 2

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Page 3

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Start Date: 3/6/2012

Required Date: 3/14/2012

Start Qty: 6.00

Required Qty: 6.00

MS20615-4M18

Purchased

No

100

Each

354.0000

3

18

Rivet

Location

Loc Qty

Loc Code

ST323

354

118077

190

118543

164

18

NAS1149C0332R

Purchased

No

100

Each

4,263.0000

4

24

Washer

Location

Loc Qty

Loc Code

ST297

4263

118354

607

119736

196

120648

3460

24

NAS1149C0432R

Purchased

No

100

Each

2,940.0000

6

36

Washer

Location

Loc Qty

Loc Code

ST297

2940

117291

1940

119124

1000

36

EP 3/12/03/15

EP 3/12/03/15

EP 3/12/03/15

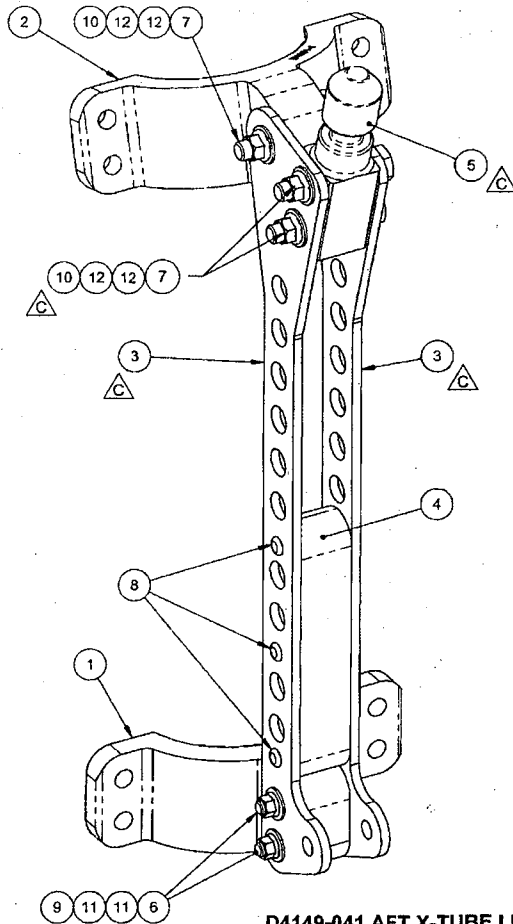
Dart Aerospace Ltd

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NOTE: Date & initial all entries



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

81007

RELEASED
2011-02-23

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D4149**
REV. C
SHEET 1 OF 5
TITLE **AFT X-TUBE LUG ASSY**
SCALE **NTS**
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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7

6

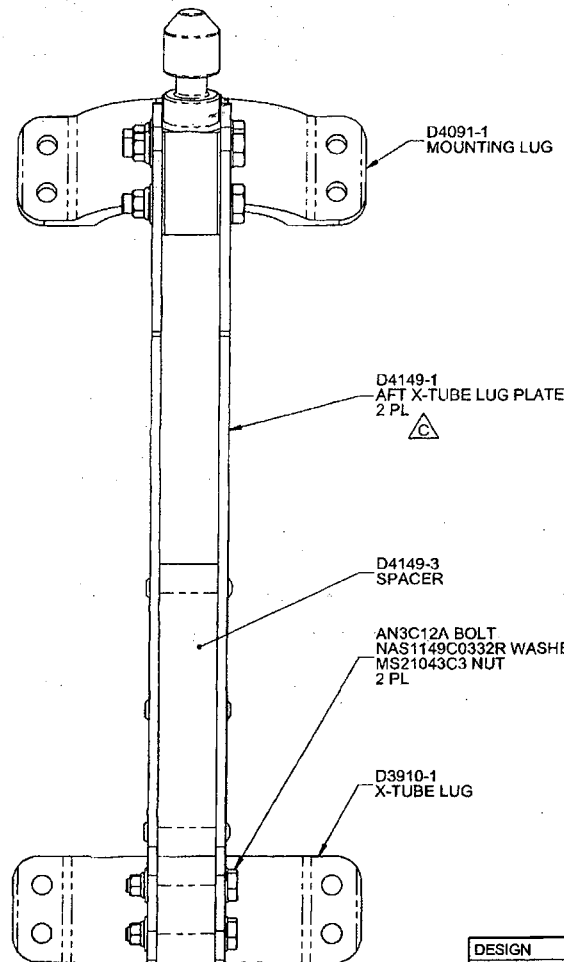
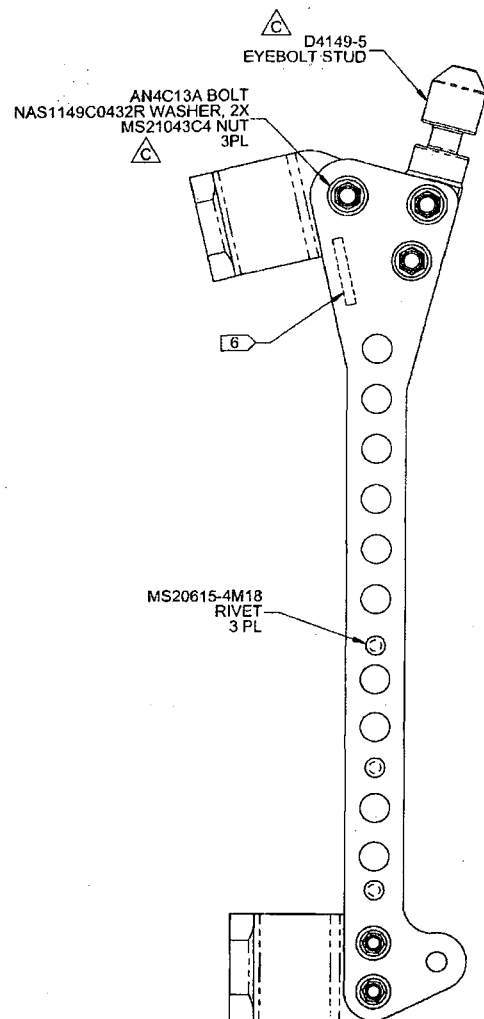
5

4

3

2

1



81007

RELEASED
2011-02-24

D4149-041 AFT X-TUBE LUG ASSY

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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8

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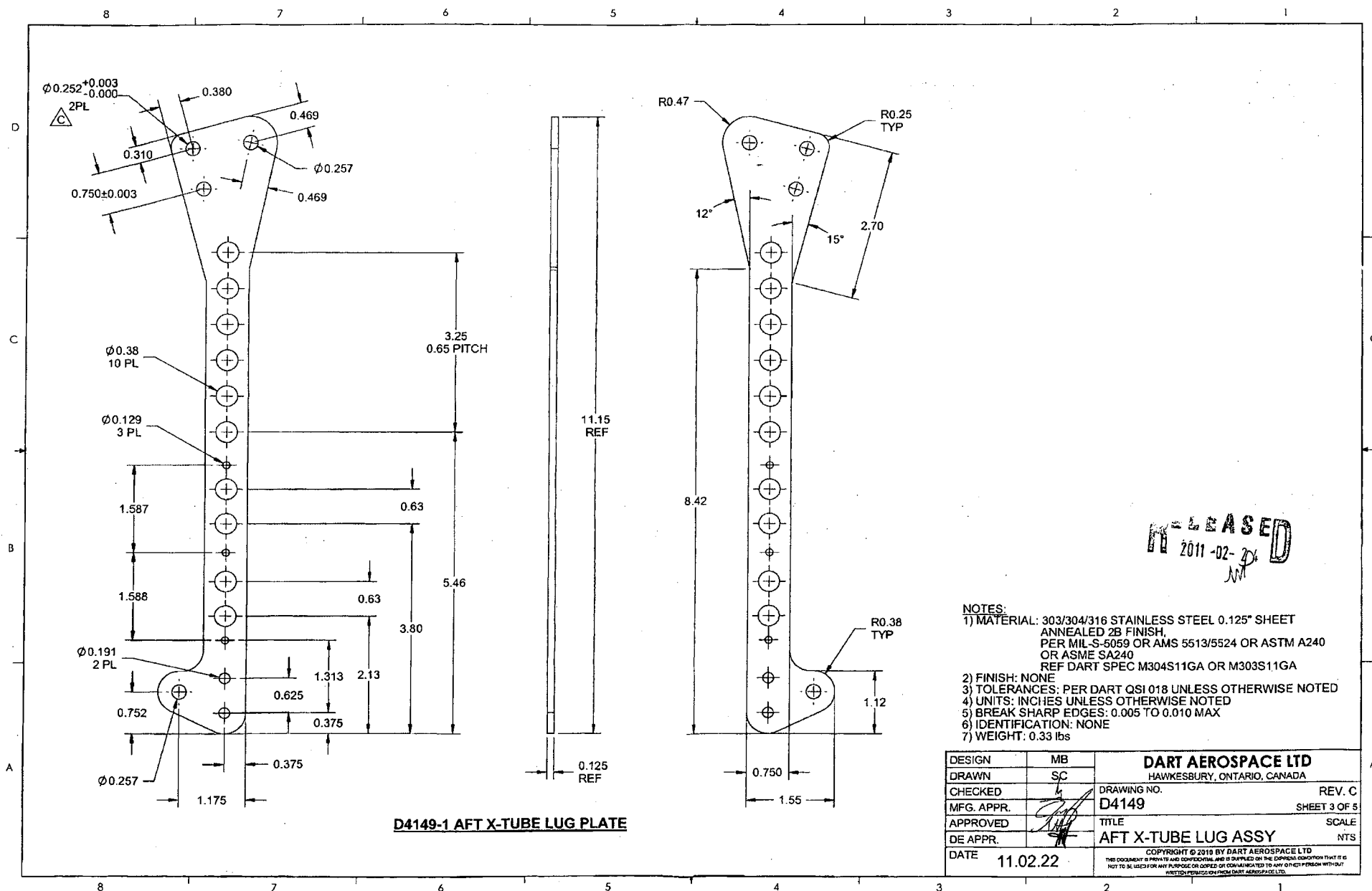
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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RELEASED
2011-02-24

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET
ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240
OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4149	REV. C
MFG. APPR.		SHEET 3 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	
DATE	11.02.22	NTS	

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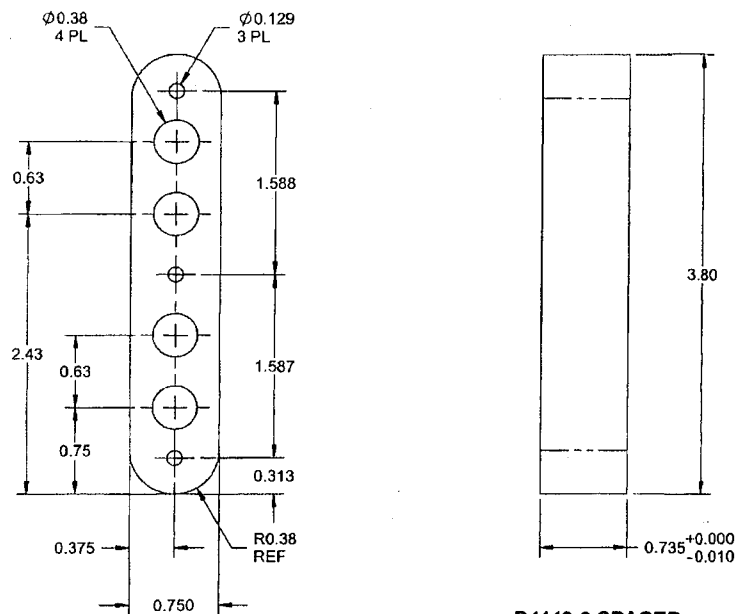
Dart Aerospace Ltd

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NOTE: Date & initial all entries



D4149-3 SPACER

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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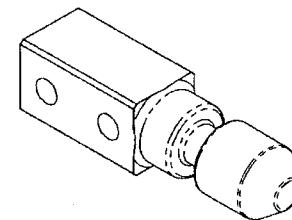
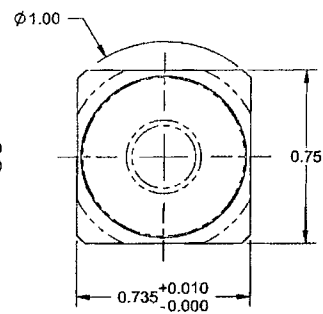
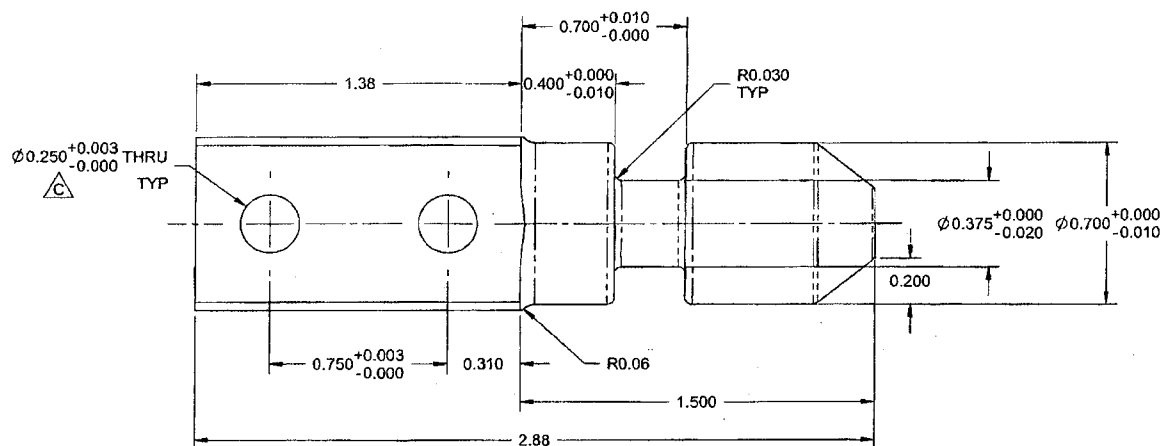
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D4149-5 EYEBOLT STUD

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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